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Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D5417-1
Job Sheet 202771



Part No: D5417-1

Job Qty: 20 pcs *30 D.*

Part Name: Support Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: TBD D5417 REV:A IPP REV:A NEW ISSUE 16-09-28 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	11/29/19	11/29/19	0.00	1.00	Bandsaw - 1		
110	HAAS 4 Axis - B4B	20 pcs	11/29/19	11/29/19	0.50	3.33	HAAS - 1 - B4B		<i>DJP 19-11-27</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S234358



Part: D5417-1

Job No: 202771

Serial No/Batch: S234358

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/24/19

130 QC 8	20 pcs	11/29/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	DAS
				QC 2 - 73	73 19-11-26
				QC 2 - 69	9-89
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	S.C.-L-19-11-21
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	11/29/19	0.00 2.00	QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 28 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	20 pcs	11/29/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160 Spray Paint - 2 - B4B	20 pcs	11/29/19	0.00	2.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
170 QC 14	20 pcs	11/29/19	0.00	0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	

Plex 11/1/19 1:39 PM Dart.lajeunesse.marie

663 DEC 11 2019

1 RA 19-12-12

DAS
81
9-89

[illegible]

**DAS
82
9-89**

**DAS
81
9-89**

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
200	QC 21 - SA	20	11/29/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - CUT AT 2.500"
Descriptions: 110 - (HAAS CNC Vertical Machine), 1-Machine per folio FB750. DWG REV: A FOLIO REV: AA
DEBURR
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (QC7-Inspect Chemical Conversion Coat)
160 - (Spray Paint / NDT Room), ***MASK PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1- PRIME PER DART QSI 005 4.2.1.3.3 PRIMER BATCH: 529198 2- PAINT WHITE PER DART QSI 005 4.2.2.4 PAINT BATCH: 5291052
170 - (QC14- Inspect Spray Paint)
180 - (Identify as per dwg & Stock Location: _____)
200 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X01.500	6061T6 Bar 0.500 X 1.500	4.2000 ft (.21 ea)	100-Bandsaw - 1	<u>5232775</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X01.500	4	3	0

Part Specifications	
Specifications could not be found.	

C.167
used

NCR No.

Job: _____		DISPOSITION			DEPARTMENT/PROCESS										
Part No. _____		Rework Scrap Use-as-is			Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality				
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY											
				Pressure/Forced			Contamination			Power Loss/Surge			Positioned Wrong		
				Bending			Misaligned/off center			Folio/Program			Outside Tolerance		
				Crushing			BOM/Route			Grain Direction			Drawing		
Cracks			Broken/Damage/Defect			Weld			Finish						
Crimp/Kink/Ripple/Wave/Twist			Incomplete/Unclear Instructions			Wrong Stock Pulled			Part Lost/Missing						
Marks/Chatter			Drill Holes			Out of Sequence			Misread						
Mislabeled			Fit/Function			Off-set/Set-up									
Other/Details:															
Completed By				Lead hand / Supervisor											
QC / QA Coordinator															